

Work Order ID 62961

Thursday, October 14, 2010 12:39:31 PM



Page 1

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ring

Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3413	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet
304 1/4" x 4"

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 10-10-26



110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-10-26

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 10/10/26

counted
+22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

ES 10/10/27 22

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Siololo 22

counted

(22)

150

0.00



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M115291

Memo

0.00

Powder Coating

START TIME: *1:45* OVEN TEMPERATURE:
400° FINISH TIME: *2:15*

22 BL 10-10-28.

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, October 14, 2010 12:39:34 PM

Page 1

Work Order ID: 62961

Parent Item: D3413-1

Parent Item Name: Ring



Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A ☐ 05.09.13 ☐ New issue ☐ KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000 304 BAR .250 x 4.00		Purchased	No			100	f	0.0000	0.25	5.263158	S.5		



10-10-24

115953

115953



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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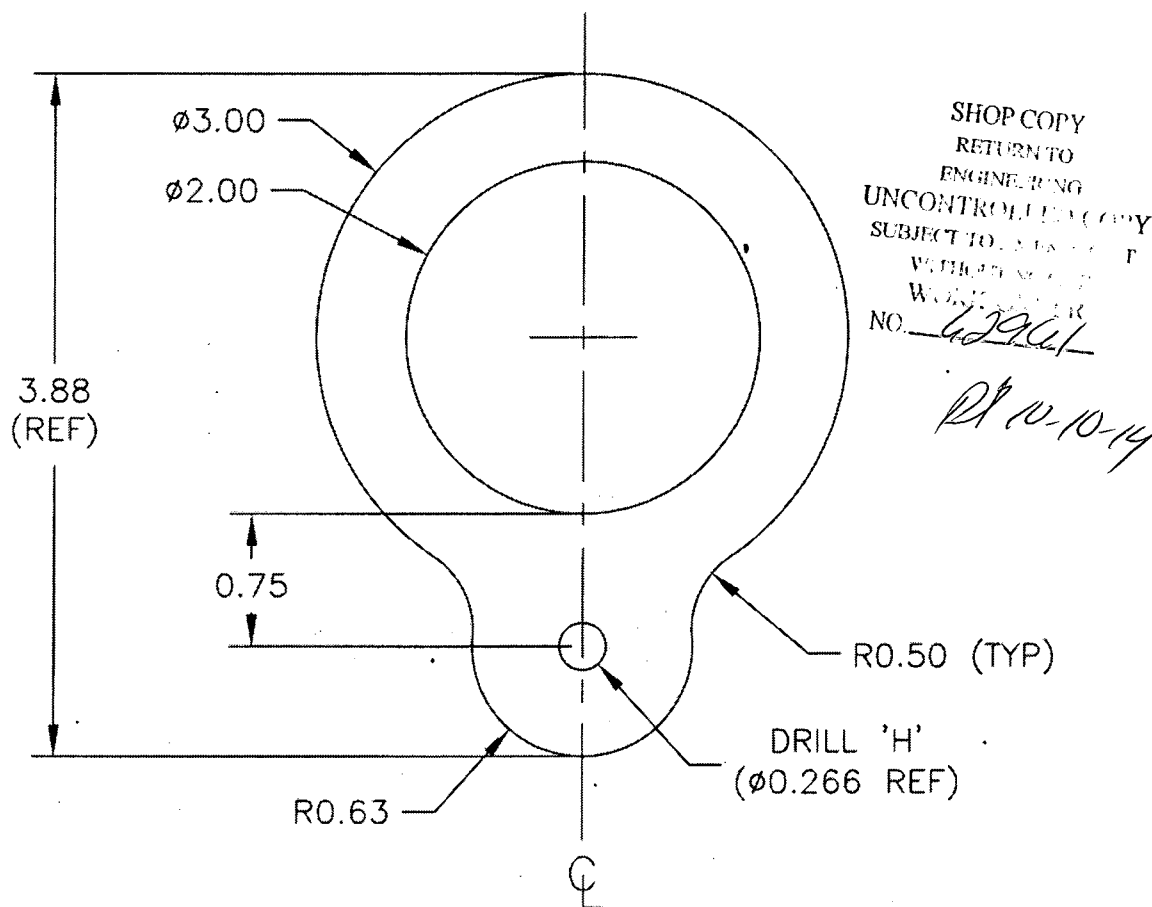
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]***D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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